

5166376



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3914-041
Job Sheet 188196



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 3/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Large Fab - Basket - 1	1 pcs	3/4/19		0.00	6.67	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
110	QC 9	1 pcs	3/4/19		0.00	0.00	Large Fab - 9	
							QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	DAS
							QC 9 - 43	43
							QC 9 - 50	9-89
120	QC 5	1 pcs	3/4/19		0.00	0.00	QC 9 - 9	
							QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	
							QC 5 - 42	
							QC 5 - 43	DAS
							QC 5 - 49	43
							QC 5 - 51	9-89
							QC 5 - 58	

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	3/4/19	0.00 0.40			Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
135 QC 3	1 pcs	3/4/19	0.00 0.00			QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 26	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 38	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 6	
						QC 3 - 68	
						QC 3 - 9	
140 Handfinish - 3-1 - WingWalk-B4B	1 pcs	3/4/19	0.00 0.80			Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	3/4/19	0.00 0.00			QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 26	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 38	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 6	
						QC 3 - 68	
						QC 3 - 9	
160 Packaging 3-1 - Stock - B4B	1 pcs	3/4/19	0.00 0.00			Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	

DAS
15
9-89DAS
19
9-89

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	DAS
					Packaging 3 - 35 - B4B	21
					Packaging 3 - 36 - B4B	828
170 QC 21 - SA	1 pcs	3/4/19	0.00 0.00	QC 21 - SA - 21	21	MAR 27 2019
				QC 21 - SA - 70	9-88	MAR 27 2019
				QC 21 - SA - 53		

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____ - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld
 Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on
 basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure
 to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of
 mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand
 area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Master Unit #008723

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5155219
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5156434
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5156064
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5110937
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	5161565
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5154112
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5159249

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	75	0
	D3914-1	2	6	0
	D3914-7	2	8	0
	D4016-3	3	150	0
	D4018-5	9	63	0
	D4020-5	1	2	0
	D4021-3	1	4	0
	D4035-043	2	8	0
Part Specifications				
Specifications could not be found.				

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Status: New

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Job Tracking No:

Due Date: 3/4/19

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Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/4/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs		3/4/19	0.00	6.67	Large Fab 1		
110	QC	1 pcs		3/4/19	0.00	0.00	QC9		
120	QC	1 pcs		3/4/19	0.00	0.00	QC5		
130	Powdercoat	1 pcs		3/4/19	0.00	0.40	Powdercoat4		
135	QC	1 pcs		3/4/19	0.00	0.00	QC3		
140	HandFinish	1 pcs		3/4/19	0.00	0.80	HandFinish3		
150	QC	1 pcs		3/4/19	0.00	0.00	QC3		
160	Packaging	1 pcs		3/4/19	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea		3/4/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	
D3914-1	Rib	2 pcs (2 ea)	90-Start up Operation	
D3914-7	Rib	2 pcs (2 ea)	90-Start up Operation	
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	90-Start up Operation	
D4018-5	Rib	9 pcs (9 ea)	90-Start up Operation	
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	90-Start up Operation	
D4021-3	Data Plate	1 pcs (1 ea)	90-Start up Operation	
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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90-Start up Operation

D2581	2	15	0
D3914-1	2	6	0
D3914-7	2	6	0
D4016-3	3	185	0
D4018-5	3	18	0
D4020-5	1	6	0
D4021-3	1	12	0
D4035-043	2	4	0

Part Specifications

Specifications could not be found.

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S166376



Container No: S166376



Part: D3914-041

Job No: 188196

Serial No/Batch: S166376

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

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Date: 03/27/19